

375 . 058W

Work Order ID 86912

86912

Page 1

July-09-12 11:01:48 AM

Item ID: D2649 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cross Bolt Spacer
 Start Date: 7/09/12 Start Qty: 200.00 *200* Cust Item ID:
 Required Date: 8/17/12 Req'd Qty: 200.00 *200* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/07/10 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2649	Rev B1								

100 0.00
 100 Hardinge CNC LATHE SMALL 208 ϕ
 Hardinge Memo 0.00 DAS 12/7/21
 Hardinge CNC Lathe Small Machine as per folio FA214 on cobra machine 13 8-89

110 0.00
 110 QC2- Inspect parts off machine FAI/FAIB 208 ϕ
 QC Memo 0.00 DAS 12/7/21
 Quality Control

120 0.00
 120 QC8- Inspect parts - second check 208 ϕ
 QC Memo 0.00 DAS 12/07/22
 Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

86912

July-09-12 11:01:48 AM

N900040100

Setup Start *NS1*

Stop *NS2*

200

200

Reference:

Run Start *NR1*

Stop *NR2*

125

1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

Identify as per dwg & Stock Location: LG

130

Packaging

STOCK IN SKIDTUBE CELL

QC21- Final Inspection - Work Order Release

140

0.00

Quality Control

208 Ø BR 12/07/25

208 ϕ BE 12/07/25

MLJ 12107 125

ME
12-07-25

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July-09-12 11:01:48 AM

Required Qty: 200.00

12/7/21

60 ft

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NOTE: Date & initial all entries

Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

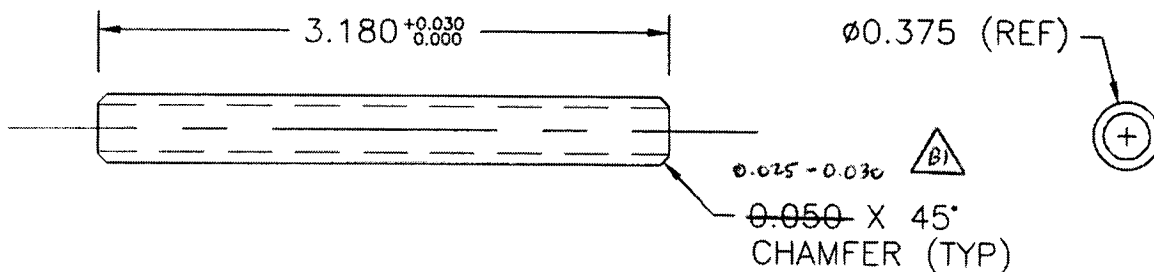
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DESIGN <i>DM</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DM</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER	
B1	CP 02.06.13	REDUCE CHAMFER PER TSR 1246.	

RELEASED
98.01.20 DS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86912 MLD
12/07/10

MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.375 DIA 0.058 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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